

Work Order ID 149056

Tuesday, July 19, 2016 10:18:23 AM

149056

PRELIMINARY ISSUE

Page 1

Item ID: D206-628-134PHI **POSITIVE** Accept

Revision ID: PRELIM

Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 407

Start Date: 7/19/2016 Start Qty: 3.00 *3*

Required Date: 7/27/2016 Req'd Qty: 5.00 *3*

Reference:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: **DAS 21** Date: **JUL 19 2016** Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
N/A	Rev N/A	JUL 26 2016	DAS 6						

100	Document Control	0.00	DAS 6						
100	DOCUMENT CONTROL								
DC	Memo	0.00		-134PHI CHG001					
Doc.Control -USB or Paperwork	Photocopy blue file and type labels as per PPP D206-628-024 CHG 003								

X2 **DAS 27**
9-89
AUG 04 2016

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAS 28
9-89
JUL 26 2016

B146713 (X1RH)

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.02							
Quality Control									

X2 **DAS 27**
9-89
AUG 04 2016

B146715 (X1RH)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER : _____																							

Work Order ID 149056

149056

Page 2

Tuesday, July 19, 2016 10:18:23 AM

Item ID: D206-628-134PHI Accept

N900040100

Setup Start *NS1*

Revision ID: PRELIM

Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 407

Stop *NS2*

Start Date: 7/19/2016 Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 7/27/2016 Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	DAS 28 9-89 Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D206-628-034								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.05							
Quality Control									

DAS
28
9-89
AUG 04 2016

POSITIVE RECALL
EFFECTIVE 160722 AUTH 6
RELEASED 9 DATE 16-03-06

OS per ECN 16-620

SU AUG 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 149056

149056

Parent Item: D206-628-134PHI

D206-628-134PHI

Parent Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 407

Start Date: 7/19/2016

Required Date: 7/27/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IIPP REV:A 14.09.23 NEW ISSUE LL VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status												
D2731-3PHI *D2731-3PHI* Mounting Lug DAS 27 9-89		Manufactured	No			110	Each	0.0000	4	12 8 147130	SD	DAS 28 9-89													
D2732 *D2732* Rubber Cushion (Sper foot) DAS 27 9-89		Manufactured	No			110	f	279.3947	2	64 M 147721	P	DAS 28 9-89													
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST412</td><td>279.3947358</td><td></td></tr><tr><td>117118</td><td>5E-10</td><td></td></tr><tr><td>143793</td><td>279.394736</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST412	279.3947358		117118	5E-10		143793	279.394736	
Location	Loc Qty	Loc Code																							
ST412	279.3947358																								
117118	5E-10																								
143793	279.394736																								
3.00" long D2842-044 *D2842-044* Step Assembly, RH 205 Float (PHI) DAS 27 9-89		Manufactured	No			110	Each	0.0000	1	32 B146715		DAS 28 9-89													
D3394-041PHI *D3394-041PHI* Lug DAS 27 9-89		Manufactured	No			110	Each	0.0000	4	12 8 147131	SD	DAS 28 9-89													

JUL 26 2016

JUL 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 2

Work Order ID: 149056

149056

Parent Item: D206-628-134PHI

D206-628-134PHI

Parent Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 407

Start Date: 7/19/2016

Required Date: 7/27/2016

Start Qty: 3.00

Required Qty: 3.00

AN4C14A
AN4C14A
Bolt

Purchased No

110 Each

174.0000

8

24/16

**

PC DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	25	
118706	20	
123021	5	
over003	30	
m134370	30	
ST344	119	
131677	19	
m131452	21	
m132249	13	
m132767	14	
m133628	52	

AN4C15A
AN4C15A
Bolt

Purchased No

110 Each

146.0000

4

12/8

**

IX M131377 PC DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	10	
120360	10	
OVER002	50	
M132763	20	
M133485	30	
ST343	86	
M130716	40	
M131377	24	
M132189	8	
M132823	14	

JUL 26 2016

Tuesday, July 19, 2016 10:18:27 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐	Pressure/Forced	☐	Temperature/Cure
Design ☐	☐	Operator ☐		☐	Bending	☐	Set-up
Doc/Data ☐	☐	Offset/Setup ☐		☐	Centre Not Concentric	☐	BOM/Route
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks	☐	Broken/Damage/Defect
Handling/Pre ☐	☐	Training ☐		☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material ☐	☐	Use for Testing ☐		☐	Cuffs	☐	Contamination
Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____			
Misidentified ☐	☐	Past Due ☐					

Picklist Print

Tuesday, July 19, 2016 10:18:27 AM

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Work Order ID: 149056

149056

Parent Item: D206-628-134PHI

D206-628-134PHI

Parent Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 407

Start Date: 7/19/2016

Required Date: 7/27/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149C0432R

Purchased No

110 Each

977.0000

24

72-48

NAS1149C0432R

WASHER

**

PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	801
m125807	427
m134676	374
ST266	176
m134676	176

D3672-3

Manufactured No

110 Each

717.0000

24

72-48

D3672-3

Washer, Phenolic

**

PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	100
133083	52
134449	48
FP001	213
132639	213
ST049	404
142571	13
146277	391

JUL 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 149056

149056

Parent Item: D206-628-134PHI

D206-628-134PHI

Parent Item Name: Heli-Access-Step™ RH - High Gear, Float Compatible 407

Start Date: 7/19/2016

Required Date: 7/27/2016

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

110

Each

753.0000

12

36-24

MS21043-4

Nut

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	17	
m132803	17	
OVER007	300	
m134754	300	
ST302	396	
m134502	96	
m134943	300	

24

JUL 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. G OR LATER APPROVED REVISION

REF. FAA STC: SA00500SE
REF. TCCA STC: SH98-14
REF. EASA STC: EASA.IM.R.S.01339
REF. ANAC STC: 2009S08-23/-24

DAS
27
9-89
REFERENCE ONLY

PURPOSE:

TO ADD D206-628-123/-124/-133/-134 FLOAT STEPS TO PROVIDE A FLOAT STEP INSTALLATION OPTION WITHOUT THE D2844-1/-3 ARMS FOR INSTALLATION WITH DART FLOATS PER CUSTOMER REQUEST.

PARTS LIST:

PARTS LIST OF SECTION 5.2 OF IIN-D206-628 REV. G IS AMENDED AS SHOWN BELOW TO REFLECT THE ADDITION OF D206-628-123/-124/-133/-134 FLOAT STEP CONFIGURATIONS.

Qty -123	Qty -124	Qty -133	Qty -134	Part Number	Description
X				D206-628-123	206 L/L1/L3/L4 FLOAT STEP INST. LH
	X			D206-628-124	206 L/L1/L3/L4 FLOAT STEP INST. RH
		X		D206-628-133	407 FLOAT STEP INST, LH
			X	D206-628-134	407 FLOAT STEP INST, RH
		4	4	D2731-3	MOUNTING LUG
4	4			D2731-7	MOUNTING LUG
8	8	8	8	D2732-30	RUBBER CUSHION /
1		1		D2842-043	FLOAT STEP ASSEMBLY LH
	1		1	D2842-044	FLOAT STEP ASSEMBLY RH
		4	4	D3394-041	MOUNTING LUG
		4	4	*D3394-1	*LUG
		8	8	*MS35489-93	*GROMMET
4	4			D3394-043	MOUNTING LUG
4	4			*D3394-3	*LUG
8	8			*MS35489-93	*GROMMET
4	4	8	8	AN4C14A	BOLT /
8	8	4	4	AN4C15A	BOLT /
24	24	24	24	NAS1149C0432R	WASHER (OR AN960C416L)
24	24	24	24	D3672-3	WASHER (OR NAS1515H4L)
12	12	12	12	MS21043-4	NUT

* DENOTES THAT PARTS INCLUDED IN ASSEMBLY ABOVE

A	NEW ISSUE	AK	16.05.25
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AK		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9748	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ADD -123/-124/-133/-134 STEPS NTS	
DATE	16.05.25	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Work Order ID 149056

Tuesday, July 19, 2016 10:18:23 AM

149056 PRELIMINARY ISSUE

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Item ID: D206-628-134PHI
 Revision ID: PRELIM
 Item Name: Heli-Access-Step™ RH - High Gear Float Compatible 407
 Start Date: 7/19/2016 Start Qty: 300
 Required Date: 7/27/2016 Req'd Qty: 300

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Reference:

DAS

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9-89

Approvals:

Process Plan:

Date: JUL 19 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100	Document Control	0.00							
100	DOCUMENT CONTROL	0.00							
DC	Memo								
Doc.Control -USB or Paperwork	Photocopy blue file and type labels as per PPP D206-628-024 CHG 003								
110	Pick Kit	0.00							
110	Packaging	0.00							
Packaging	Memo								
120	QC4- 100% Inspect kits for completeness	0.00							
120	QC	0.02							
Quality Control	Memo								

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AUG 04 2016

134PHI
 see attachment 001
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[illegible]